shg Monday 24/03 Rev E DAS 16 9-89 14/03/20

Work Order ID 115216

March-18-14 11:40:14 AM

115216 ~~PRELIMINARY ISSUE~~

Item ID: D4541-1 D4541-1 B115216

Revision ID:

Item Name: Bracket

Start Date: 3/18/14 **Start Qty:** 8.00 *8*

Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*

Reference:

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-03-18

QC: _____ **Date:** _____

Tooling: _____ **Date:** _____

SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4541 Revision Nbr: PE2 M Rev E DAS 27 ~~DAS~~ 10 9-89									
100		0.00							
100						8	0		JM14-03-25
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1- Cut as per dwg Prog rev: PE2 Dwg rev: PE2 2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						8	0		JM14-03-25
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 115216

March-18-14 11:40:14 AM

115216

Item ID: D4541-1
Revision ID:
Item Name: Bracket
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 27 9-89 14/3/25				8			
120 QC Quality Control	Memo	0.00				Inspect as per Dwg PFD			
150	Identify as per dwg & Stock Location: St 531	0.00							
150 Packaging Packaging	Memo	0.00					DAS 06 9-89 MAR 2 6 2014		
160	QC21- Final Inspection - Work Order Release	0.00							
160 QC Quality Control	Memo	0.00				MLJ 14-0326 DAS 27 9-89 14/3/26			

(121) Small Fab ! Bend individual tabs as per dwg → DAS 30 9-89

Release Dwg as per Rev E 14/03/25

POSITIVE RECALL
EFFECTIVE 14.03 DAS 16 9-89 AUTH
RELEASED DAS 27 9-89 DATE 14/03/25

DAS 10 9-89 (122) QC5 → DAS 27 9-89 14/3/25 (8)

(123) Chemical conversion → (8) 14/3-25 (124) QC7 → 14/3/25 Inspect as per Dwg

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

March-18-14 11:40:17 AM

Work Order ID: 115216 *115216*

Parent Item: D4541-1 *D4541-1*

Parent Item Name: Bracket

Start Date: 3/18/14 **Required Date:** 4/01/14

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC IPP REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	410.6032	0.416	4			
M6061T6S.032									**				
6061-T6 Sheet 0.032"													

JM14-03-25

Location	Loc Qty	Loc Code	
MAT021	410.60317		
123483	8.57		
m125822	17		
m127272	128.75317		
m128054	256.28		128054

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	115216
Description: Bracket	Part Number:	D4541-1
Inspection Dwg: D4541 **Rev:** ~~B~~ PE2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099"	—		V	JKmos
Ø0.257	+0.006/-0.001	0.258"	—		V	
1.00	+/-0.030	1.005"	—		V	
0.688	+/-0.010	0.691"	—		V	
0.344	+/-0.010	0.346"	—		V	
0.312	+/-0.010	0.312"	—		V	
0.26	+/-0.030	0.264"	—		V	
1.09	+/-0.030	1.097"	—		V	
~~0.80~~ 0.80"	+/-0.030	0.798"	—		V	
0.320	+/-0.010	0.320"	—			
~~1.45~~ 1.65"	+/-0.030	1.645"	—			
21.3	+/-0.100	21.3"	—			
30.6	+/-0.100	30.6"	—			
0.032	+/-0.010	0.032"	—			
			DAS 27			

Measured by:	JM	Audited by:	~~9-89~~	Preliminary Approval:	
Date:	14-03-25	Date:	14/3/25	Date:	

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	
B	13.06.05	Dwg Rev updated	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

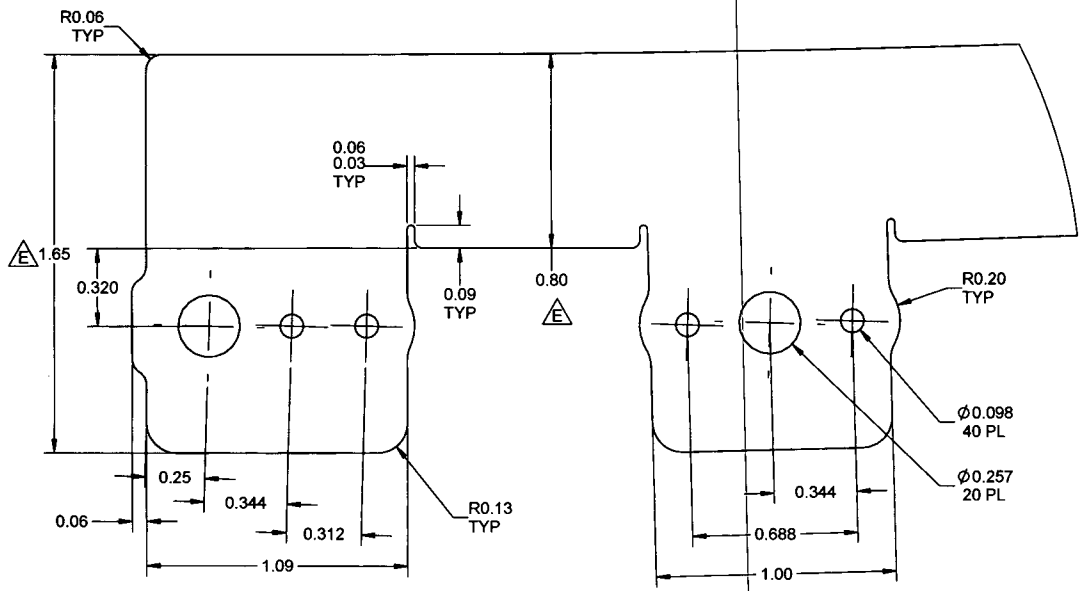
FAULT CATEGORY

Landing Gear

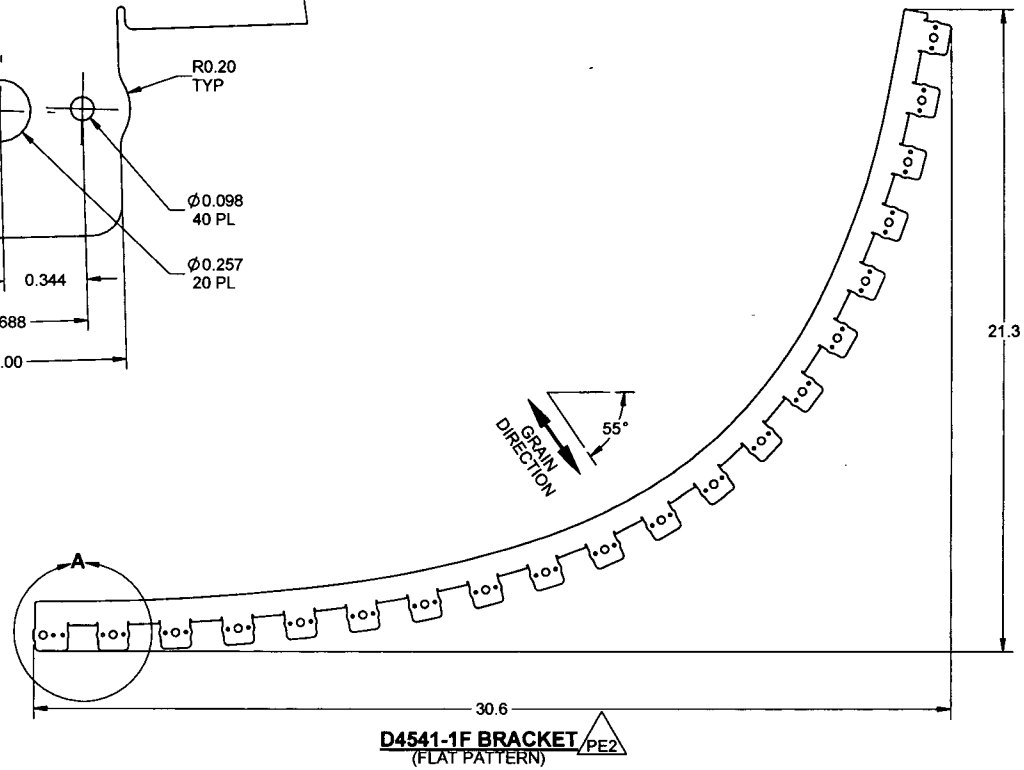
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
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☐ Grain
☐ Hardware
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



DETAIL A
TYP TAB DETAIL
SCALE 8X



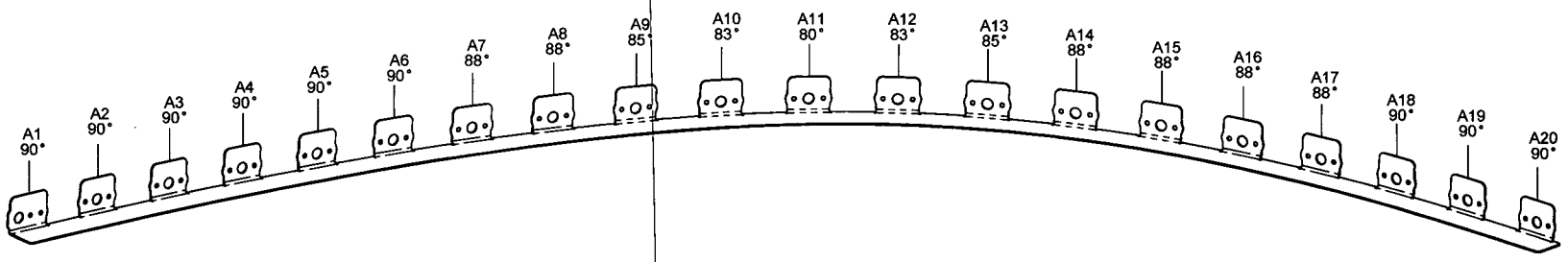
D4541-1F BRACKET PE2
(FLAT PATTERN)

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.15 lbs
8) PROFILE PER DRAWING FILE "D4541-1F-REVE.DXF"
8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

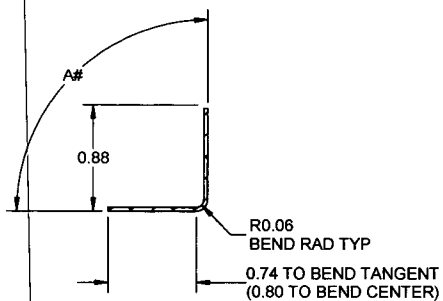
PRELIMINARY E2
14.03.07 (AJS)

DESIGN	CP	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4541 REV. PE2
MFG. APPR.		SHEET 2 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	14.03.07	

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D4541-1 BRACKET PE2



PRELIMINARY E2
14.03.07 (AJS)

NOTES:
1) MATERIAL: MAKE FROM D4541-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.15 lbs
8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

REV.	DESCRIPTION	BY	DATE
PE2	ADDED -1 & -2 BENT. SHT 2 & 4 ZN C6 0.80 DIM WAS 0.60. SHT 10 ZN C7 & C4 1.75 DIM WAS 1.55 -5 & -6 UPDATED ACCORDINGLY. SHT 13 ZN C8 2.5 DIM WAS 2.3, 1.66 DIM WAS 1.46. -7 & -8 UPDATED ACCORDINGLY.	AJS	14.03.07
D	ADD BENT SHAPES -3/-4/-7/-8	CP	13.02.04
C	D4541-5F WAS -5; ADD -5/-6; RMV FINISH (-1/-2/-3/-5F/-7); 0.70 WAS 0.60 (ZN D1-3)	CP	12.04.20
B	-5: 1.55 WAS 1.45 (ZN C4-4)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D4541 REV. PE2
MFG. APPR.		SHEET 1 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	14.03.07	

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DART AEROSPACE LTD

DART AEROSP

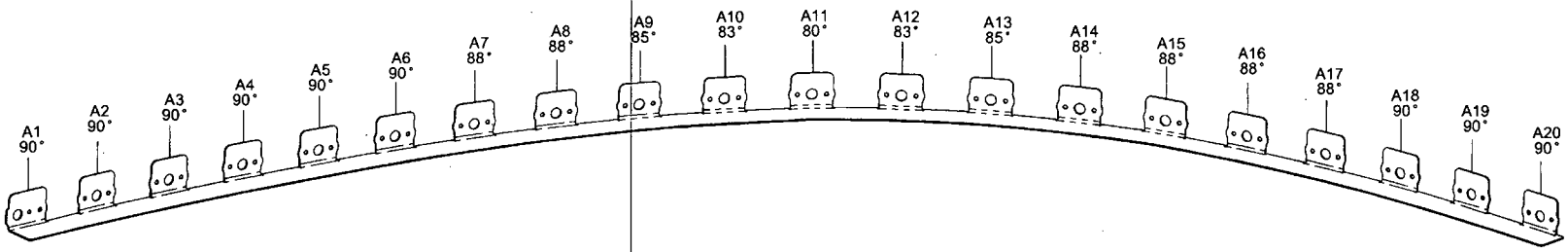
Description: Bracket Work Order: 175216

Inspection Drawing: D4541 Rev: PE 2 Part Number: D4541-1

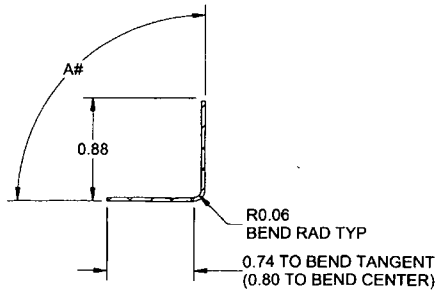
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.88	+/- .010	.886	✓		V	SM-11
.74	+/- .030	.746	✓		V	SS-11
90°	+/- ½°	90°	✓		Angle protractor & pin gauge	SB 7
88°	+/- ½°	88°	✓		Angle protractor	SB 7
85°	+/- ½°	85°	✓		Angle protractor	SB-7
83°	+/- ½°	83°	✓		Angle protractor	SB-7
80°	+/- ½°	80°	✓		Angle protractor	SB-7

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessa*
DAS 30 9-89	DAS 36 9-89	DAS 27 9-89	
Date 14/03/25	Date 14/03/25	Date 14/3/25	Date



D4541-1 BRACKET (E)



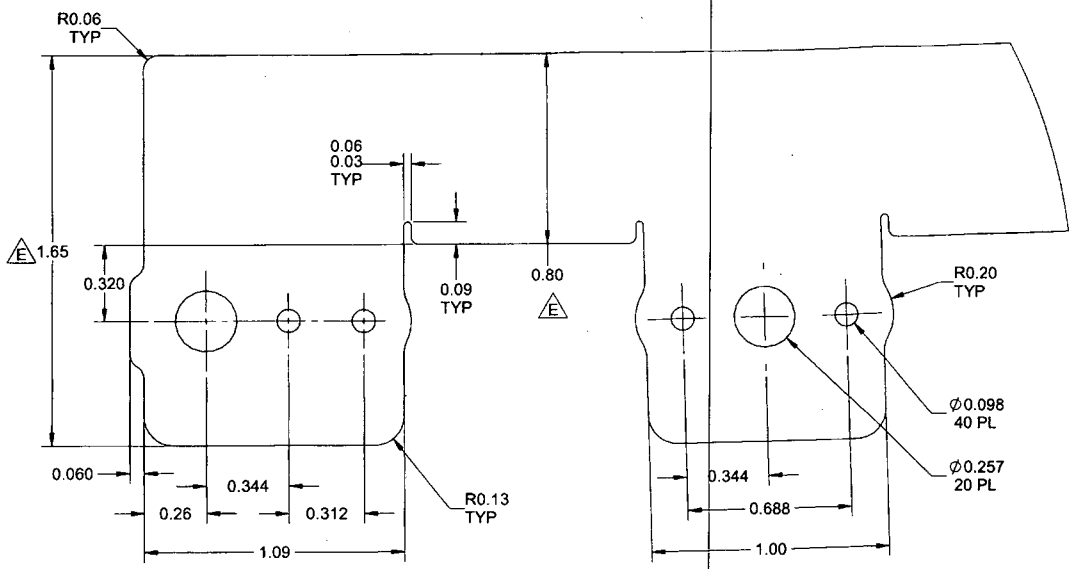
RELEASED
2014-03-26

NOTES:
1) MATERIAL: MAKE FROM D4541-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.15 lbs
8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

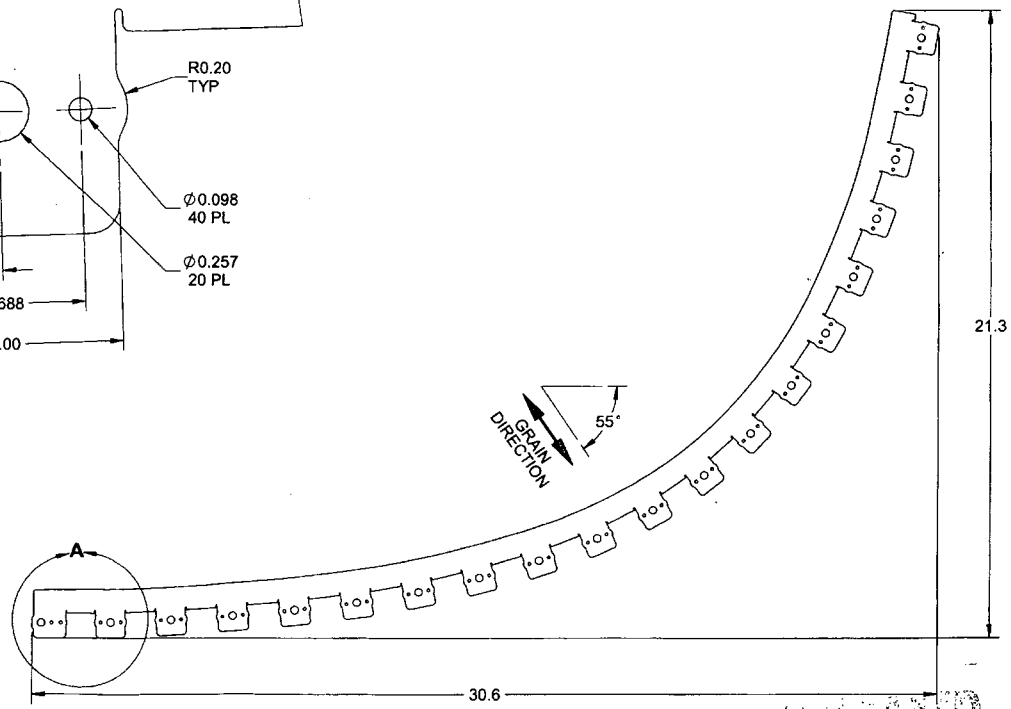
REV.	DESCRIPTION	BY	DATE
E	ADDED -1 & -2 BENT. SHT 2 & 4 ZN C6 0.80 DIM WAS 0.60. SHT 10 ZN C7 & C4 1.75 DIM WAS 1.55 -5 & -6 UPDATED ACCORDINGLY. SHT 13 ZN C8 2.5 DIM WAS 2.3, 1.66 DIM WAS 1.46. -7 & -8 UPDATED ACCORDINGLY.	AJS	14.03.07
D	ADD BENT SHAPES -3/-4/-7/-8	CP	13.02.04
C	D4541-5F WAS -5; ADD -5/-6; RMV FINISH (-1/-2/-3/-5F/-7); 0.70 WAS 0.60 (ZN D1-3)	CP	12.04.20
B	-5: 1.55 WAS 1.45 (ZN C4-4)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4541 REV. E
MFG. APPR.		SHEET 1 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	14.03.07	

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DETAIL A
TYP TAB DETAIL
SCALE 8X



D4541-1F BRACKET E
(FLAT PATTERN)

RELEASED
2014 -03- 26

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.15 lbs
8) PROFILE PER DRAWING FILE "D4541-1F-REVE.DXF"
8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4541 — REV. E
MFG. APPR.		SHEET 2 OF 13
APPROVED		TITLE: BRACKET — SCALE: NTS
DE APPR.		
DATE	14.03.07	

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